

ALN Tube 3126

Work Order ID 69516

Wednesday, May 11, 2011 2:37:25 PM

ASAP



Page 1

Item ID: D3681-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacer

Start Date: 5/11/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 5/13/2011 Req'd Qty: 30.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

11-05-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3681

Rev A

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA711& DWG D3681

FOLIO REV: WJA

DWG REV: A

2-DEBURR AS REQUIRED

11/5/11

33 6

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/5/11

33 6

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11.5.11

33 6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69516

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Page 2

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Start Date: 5/11/2011 Start Qty: 30.00



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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125		0.00							
Skidtubes	Memo	0.00				33	0	BE 11/05/26	
Skidtubes	1- clean crossbolt spacer with ultra brigh aluminum cleaner before storing.								
130	Identify as per dwg & Stock Location: <u>46</u>	0.00							
Packaging	Memo	0.00				33	0	BE 11/05/26	
Packaging	***STOCK IN SKIDTUBE CELL***								
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/5/26
MF
11-05-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Wednesday, May 11, 2011 2:37:32 PM

Page 1

Work Order ID: 69516

Parent Item: D3681-1

Parent Item Name: Spacer



Start Date: 5/11/2011

Required Date: 5/13/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev A new issue 07-10-30 DD verified by:EC
 IPP Rev:B Ecn 1056 Rev A dwg DD IPP Rev:C add
 seq 125 DD 10.05.03 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.3125W.05
8

Purchased

No

100

f

164.5390

0.34

10.73684



ALUM TUBE .3125 x .058w



SA 11/5/11

Location

Loc Qty

Loc Code

MAT013

164.539

116793

1.667

116939

93.972

117400

68.9

1221

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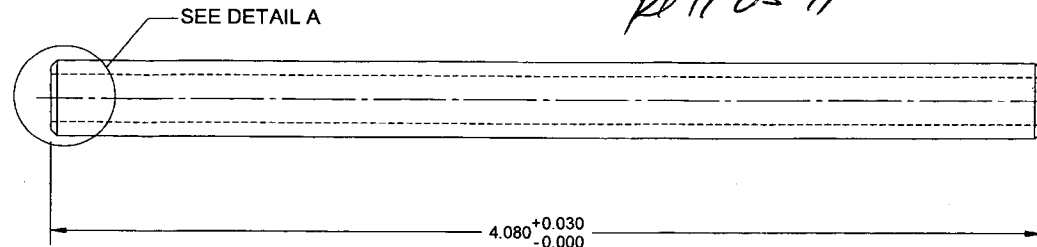
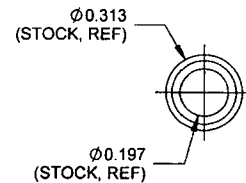
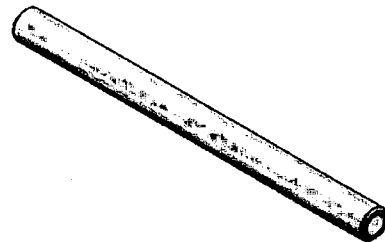
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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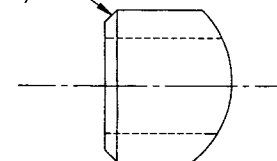
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69514

RD 11-05-11



D3681-1 SPACER

0.025 X 45°
CHAMFER
(TYP)



DETAIL A
(SCALE 4 : 1)

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/8 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

RELEASED
07-11-08

A		NEW ISSUE		DC	07.11.08
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3681 TITLE SPACER SCALE 2:1			REV. A
DRAWN	SC				SHEET 1 OF 1
CHECKED	MS				
MFG. APPR.	REP				
APPROVED	W				
DE APPR.	#				
DATE	07.11.08		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>		

Dart Aerospace Ltd

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